



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D5305-1
Job Sheet 163387



Part No: D5305-1

Job Qty: 6 ea

Part Name: Shim



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/30/17

Job Tracking No:

Due Date: 11/15/17

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG REV A IPP REV:A 15.09.04 NEW ISSUE DD VERF-II M

Ship Via:

Status: Stock

Part: **D5305-1 B163387**

Created: 9/30/17 1:20 PM DART.LAJEUNESSE.MARIE



Serial No: **S000243**

Printed By: Goldston, Justin 10/2/17 10:45 AM

Bill of Materials

Part/Part Name	Part Note
D5305-1	DWG REV A IPP REV:A 15.09.04 NEW ISSUE
Shim	
M6061T6S.050	
6061-T6 .050 Sheet	

Job Routing

Op No	Operation	Qty	Due Date	Standard		Workcenter/Supplier	
				Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	6 Ea	11/14/17	0.00	0.00	Start up container	
170	SprayPaint	6 pcs	11/15/17	0.00	0.34	Spray Paint	
180	QC	6 pcs	11/15/17	0.00	0.00	QC14	
190	Packaging	6 pcs	11/15/17	0.00	0.00	Packaging3	
200	QC21-SA	6 Ea	11/15/17	0.00	0.00	QC21	

Job BOM

Part / Item	Component Name	Quantity	Operation	Special Comments
D5305-1 B163387		36 Ea (6 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D5305-1 B163387	36	6	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Shim	0.250Inches ± 0.030	0.280 0.220		
2	Shim	0.250Inches ± 0.030	0.280 0.220		
3	Shim	2.650Inches ± 0.030	2.680 2.620		
4	Shim	4.250Inches ± 0.030	4.280 4.220		
5	Shim	0.098Inches + 0.004 - 0.001	0.102 0.097	Diameter	
6	Shim	0.050Inches ± 0.010	0.060 0.040		

Work Order Summary

Thursday, September 28, 2017 8:22:44 AM

Page 1 of 1

Criteria : Work Order ID: 163387 Item ID: D5305-1 Product Family SMALL FAB
Work Order Start Dates 7/10/2017 to 7/10/2017 11:59:59 PM Work Order Required Dates 7/14/2017 to 7/14/2017 11:59:59 PM
All References
Work Order Status Released

Work Order ID 163387 Required Qty 6.0000 Status Code Released
Item ID D5305-1 Accepted Qty 0.0000 Scrap Qty 0.0000
Item Name Shim
Current Acct Value \$14.338

Start Date	7/10/2017	Required Date	7/14/2017	Completed Date	
Standard	** Actual **		** Acct. Value **	** Variance **	** Variance % **
<u>Direct Costs</u>	<u>Total</u>	<u>Each</u>	<u>Each</u>	<u>Each</u>	<u>Each</u>
Material	\$1.002	\$0.000	\$0.229	\$0.229	100.00%
Labor	\$11.831	\$0.000	\$3.642	\$3.642	100.00%
Outplant	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
Variable Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
Fixed Burden	\$30.458	\$0.000	\$10.467	\$10.467	100.00%
Material Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
** Total **	\$43.291	\$0.000	\$14.338	\$14.338	

Item ID/Item Name	Required Qty	Issue Code	Issue Date	Issued Qty	Cost Amount
M6061T6S.050 6061-T6 .050 Sheet	0.5053		7/6/2017	0.6000	\$1.002
Total Matl Amts:					\$1.002

Work Center HandFinish

Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	Total Amounts
BOUD01												
7/24/2017												
150			0.00	0.00	0.61	0.31	2.00	\$0.000	\$6.671	\$16.651	\$0.000	\$23.321
Total:			0.00	0.00	0.61	0.31	2.00	\$0.000	\$6.671	\$16.651	\$0.000	\$23.321

Work Center Small Fab

Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	Total Amounts
BOUC01												
7/17/2017												
130			0.00	0.00	0.25	0.25	1.00	\$0.000	\$5.160	\$13.808	\$0.000	\$18.968
Total:			0.00	0.00	0.25	0.25	1.00	\$0.000	\$5.160	\$13.808	\$0.000	\$18.968

Thursday, September 28, 2017 8:22:44 AM

Work Order Summary

Page 1 of 1

Work Order ID 163387

Tuesday, June 27, 2017 11:35:58 AM

163387

Page 1

Item ID: D5305-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Shim

Start Date: 7/10/2017 Start Qty: 6.00

6

Cust Item ID:

Required Date: 7/14/2017 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: DAS 21 Date: JUL 03 2017

Tooling: _____ Date: _____

Run Start ***NR1***QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D5305	A

100	FLOW WATER JET	0.00
-----	----------------	------

100

Waterjet

FLOW CNC Waterjet

Memo

0.35

1-Cut as per Dwg
Dwg Rev: A
Prog Rev: A
2-Deburr if necessary606/17/07/06

110	QC2- Inspect parts off machine FAI/FAIB	0.00
-----	---	------

110

QC

Quality Control

Memo

0.06

606/17/07/06

120	QC8- Inspect parts - second check	0.00
-----	-----------------------------------	------

120

QC

Quality Control

Memo

0.12

6DAS 38 9-89
JUL 05 2017

Work Order ID 163387

Tuesday, June 27, 2017 11:35:58 AM

163387

Page 2

Item ID: D5305-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Shim

Start Date: 7/10/2017 Start Qty: 6.00

6

Cust Item ID:

Required Date: 7/14/2017 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

130

Small Fab

NC BRAKE

0.04

DAS
30
9-89

6

JUL 17 2017

Small Fab

Memo

0.13

FORM AS PER DWG

140

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.12

6

DAS
38
9-89
JUL 18 2017

150

150

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.28

X6

8

20170724

BER

163387

Page 3

N900040100

Setup Start *NS1*

Stop *NS2*

Customer:

6

6

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

[illegible]

Work Order ID 163387***163387***

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Tuesday, June 27, 2017 11:35:58 AM

Item ID: D5305-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Shim

Start Date: 7/10/2017 Start Qty: 6.00

6

Cust Item ID:

Required Date: 7/14/2017 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

Identify as per dwg & Stock Location: **LG56**

0.00

100

Packaging

Memo

0.00

Packaging

6

DAS

41

9-89

OCT 13 2017

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0.00

Quality Control

ML5 1710-16**ML5 1710-16**

Picklist Print

Page 1

Tuesday, June 27, 2017 11:35:54 AM

Work Order ID: 163387

163387

Parent Item: D5305-1

D5305-1

Parent Item Name: Shim

Start Date: 7/10/2017

Required Date: 7/14/2017

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A 15.09.04 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.050		Purchased	No			100	sf	59.7000	0.08	0.505263			
M6061T6S 050									**			06/17/2017	
6061-T6 .050 Sheet													

Location

Loc Qty

Loc Code

MAT021

59.7

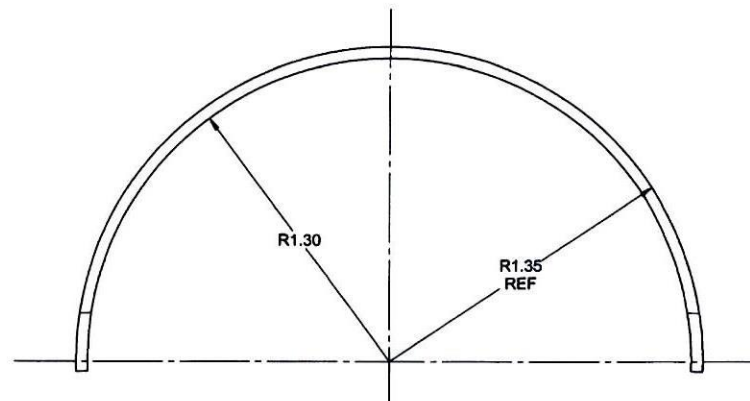
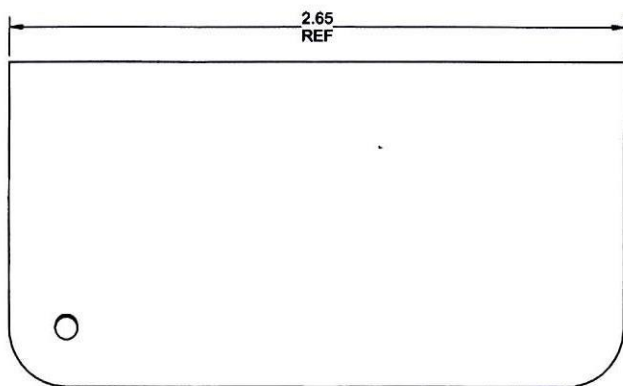
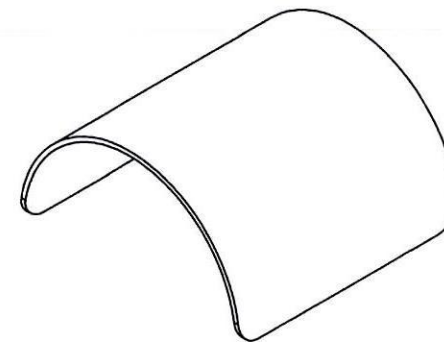
m131352

17.8

m136942

41.9

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 163387 *MJS*
170703



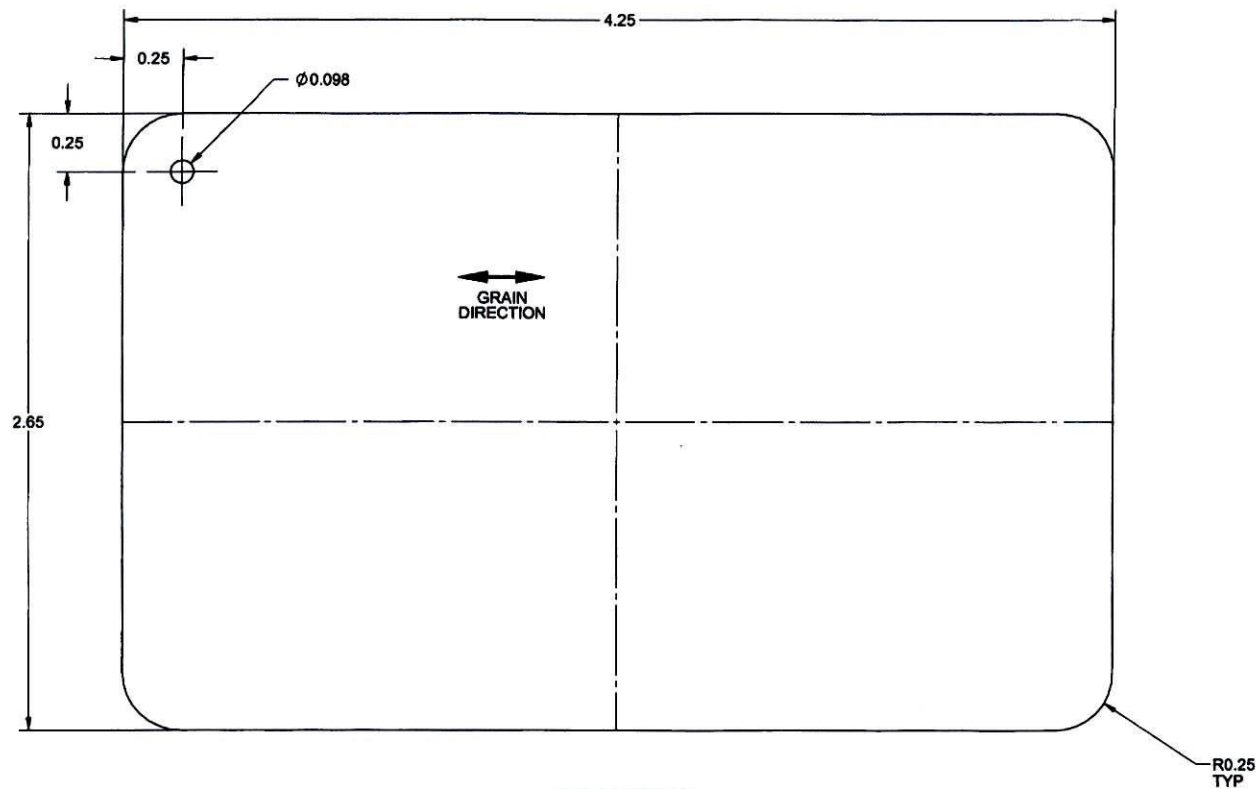
D5305-1 SHIM
(MAKE FROM D5305-1F)

RELEASED
2015 -09- 03
EW 15-624 *On*

- NOTES:
- 1) MATERIAL: MAKE FROM D5305-1F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME PER QSI 005 4.2.1
PAINT WHITE PER QSI 005 4.2.2
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.05 lbs

A		NEW ISSUE		AP	15.08.20
REV.	DESCRIPTION			BY	DATE
DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A	
DRAWN	AP				
CHECKED	AJS	DRAWING NO.		SHEET 1 OF 2	
MFG. APPR.	DD	D5305			
APPROVED	WM	TITLE		SCALE	
DE APPR.	DS	SHIM		NTS	
DATE		15.08.20		COPYRIGHT © 2015 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED



D5305-1F SHIM
(FLAT PATTERN)

R0.25
TYP

RELEASED
2015-09-03

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.051 THK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC. M6061T6S
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.05 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.05 lbs

APPROVED

DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	AJS	DRAWING NO.	REV. A
MFG. APPR.	DD	D5305	SHEET 2 OF 2
APPROVED	WM	TITLE	SCALE
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